

IN THE SPECIFICATION:

Please replace original paragraph [019] with the following marked up paragraph.

[019] Next, the cooled composite lumber is cut at the servo-controlled cutter 18 and stacked in connection with drop table 20. The servo-controlled cutter 18 can be any kind of servo-operated mechanism for cutting hardened composite materials. In a presently preferred embodiment, the servo-controlled cutter is a servo saw manufactured by Custom Downstream Systems of St-Laurent, Canada, model no. CSS 4.5-8 6.5-13. Alternatively, the servo-controlled cutter can be a servo-controlled fly knife, which employs a metal blade to cut the hardened extrudate 21. A servo-controlled fly knife can be used to cut extrudates of small cross sectional area, such as, for example small moldings.

Please replace original paragraph [019] with the following marked up paragraph.

[020] Once the composite lumber is cut, it continues to be pushed along the line to the drop table 20. ~~in~~ In various embodiments, a trigger 23 is actuated by the cut lumber as it is pushed down the line, causing the drop table 20 to tilt to one side and drop the piece of lumber into a stack of finished lumber pieces (not shown).

Please replace original paragraph [023] with the following marked up paragraph.

[023] In various embodiments, an upper surface of the table 25 of the servo-controlled cutter 18 is covered with low friction strips, comprising, for example, a Teflon™-type material, to allow the extrudate to slide over the tabletop without distorting the elastic portions of the extrudate 15. In these embodiments, the servo-controlled cutter 18 cuts pieces of lumber 21 as they are extruded in the following manner. First, the table 25 of the servo-controlled cutter 18 begins in a

home position. The speed of the extrudate 15 is obtained by way of the extrudate speed detector 22 and communicated to the servo-controlled cutter 18 via, for example, cable 24. The table 25 begins moving at the speed of the extrudate 15. Next the clamp 19 comes down to tightly clamp the hardened extrudate 21 to the servo-controlled cutter table 25, as the table 25 continues to move at the speed of the extrudate 15. Next a rotary saw blade comes up through the table 25 cutting the composite lumber at the desired length, while still moving at the speed of the extrudate. In various embodiments, the extrudate speed detector 22 is an encoder wheel having a circumference of one foot, which produces ~~4800~~ 4096 pulses per revolution. In various other embodiments, the encoder wheel produces ~~9600~~ 2048 pulses per revolution. The encoder wheel rides on the extrudate 21 and, as the extrudate ~~extrudate~~ 21 moves, the encoder wheel rotates, thereby generating pulses proportional to its rate of rotation. Accordingly, by counting pulses, the servo controlled cutter 22 can determine the length and the speed of the extrudate 15 thereby to move and properly and cut the extrudate into desired lengths. Once the blade of the cutter has cut through the extrudate 21, the blade is raised above the level of the extrudate 21 so that the extrudate can continue along the extrusion line. In various embodiments, the speed at which the extrudate is extruded can range from about 5 to about 40 feet per minute, and more particularly from about 8 to about 20 feet per minute. The variations in the rate at which the extrudate is extruded can vary by about 1 to 2 feet per minute. Advantageously, the present teachings allow for cutting of the extrudate without deforming the extrudate when the rate varies by 1 to 2 feet per minute.